Work Order ID 116988

April-24-14 8:49:53 AM

116988

Item ID: D3256-3 **Accept** *N900040100* **Setup Start** *NS1*
Revision ID: **Stop** *NS2*
Item Name: Gasket

Start Date: 4/23/14 **Start Qty:** 6.00 *6*
Required Date: 4/23/14 **Req'd Qty:** 6.00 *6*
Reference:

Cust Item ID:
Customer:

Approvals: **Process Plan:** MJS **Date:** 14-04-28 **Tooling:** _____ **Date:** _____ **Run Start** *NR1*
QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____ **Stop** *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr: D3256 / Revision Nbr: E									
100	FLOW WATER JET	0.00							
100 Waterjet	**Memo**	0.00				9	0		JM14-05-30
FLOW CNC Waterjet	1-Cut as per Dwg D3256 Rev: E Prog Rev: 12								
G89									
110	QC2- Inspect parts off machine FAI/FAIB	0.00							
110 QC	**Memo**	0.00				9	0		JM14-05-30
Quality Control									
120	QC8- Inspect parts - second check	0.00	DAS 27 9-89 14/5/30						
120 QC	**Memo**	0.00				9			
Quality Control									

DQA: _____ Date: _____

DART AEROSPACE

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: Date: Work Order update only ☐

Work Order: _____

Part No. _____

NCR No. _____

DISPOSITION

Rework ☐
Scrap ☐
Use-as-is ☐
Suspected Unapproved ☐

AGAINST DEPARTMENT/PROCESS

Skid-tube ☐ Crosstube ☐ Water Jet ☐ Engineering ☐
Machining ☐ Small Fab ☐ Prod. Eng. Coor. ☐ Quality ☐
Thermoforming ☐ Finishing ☐ Rec/Store/Packaging ☐ Other ☐
Large Fab ☐ Composite ☐ Supplier ☐ ☐

Root Cause		Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design	☐									
Doc/Data	☐									
Equip/Tooling	☐									
Handling/Pre	☐									
Material	☐									
Operator	☐									
Offset/Setup	☐									
Process	☐									
Supplier	☐									
Training	☐									
Transport	☐									
Unapproved	☐									

FAULT CATEGORY

Landing Gear

☐ Bending
☐ Centre Not Concentric
☐ Cracks
☐ Crimp/Kink/Ripple/Wave
☐ Cuffs
☐ Crushing
☐ Heat Treat
☐ Inspection Strip in Tube
☐ Marks/Chatter
☐ Turning Sequence
☐ Wave/Twist in Tube

General

☐ Bend
☐ BOM/Route
☐ Broken/Damage/Defect
☐ Burrs
☐ Contamination
☐ Countersink
☐ Cut Too Short
☐ Drawing
☐ Drill Holes
☐ Finish
☐ Fit/Function

☐ Folio/Program
☐ Grain
☐ Hardware
☐ Inspection Incomplete/Unqualified
☐ Instructions Incomplete/Unclear
☐ Misaligned/off center
☐ Mislabeled
☐ Misread
☐ Off-set
☐ Out of Calibration
☐ Out of Sequence

☐ Outside Dimensions
☐ Over/Under tolerance
☐ Part Incorrect
☐ Part Lost/Missing
☐ Part Moved
☐ Positioned Wrong
☐ Power Loss/Surge

☐ Pressure/Forced
☐ Set-up
☐ Temperature/Cure
☐ Weld
☐ Wrong Stock Pulled

☐ Other

Work Order ID 116988

April-24-14 8:49:53 AM

116988

Item ID: D3256-3 **Accept** *N900040100* **Setup Start** *NS1*

Revision ID: **Stop** *NS2*

Item Name: Gasket

Start Date: 4/23/14 **Start Qty:** 6.00 *6*

Required Date: 4/23/14 **Req'd Qty:** 6.00 *6*

Reference:

Cust Item ID:

Customer:

Run Start *NR1*

Stop *NR2*

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____

QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	Identify as per dwg & Stock Location: ST 183	0.00				9X		14-6-02	DAS 26 9-89
130									
Packaging	**Memo**	0.00							
Packaging									
140	QC21- Final Inspection - Work Order Release	0.00							
140									
QC	**Memo**	0.00				MLJ 14-06-02			
Quality Control									

MLJ 14-06-02

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

DART AEROSPACE

QA Closed: Date: Work Order update only ☐

Work Order: _____

Part No. _____

NCR No. _____

DISPOSITION

Rework ☐
Scrap ☐
Use-as-is ☐
Suspected Unapproved ☐

AGAINST DEPARTMENT/PROCESS

Skid-tube ☐ Crosstube ☐ Water Jet ☐ Engineering ☐
Machining ☐ Small Fab ☐ Prod. Eng. Coor. ☐ Quality ☐
Thermoforming ☐ Finishing ☐ Rec/Store/Packaging ☐ Other ☐
Large Fab ☐ Composite ☐ Supplier ☐

Root Cause		Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design	☐									
Doc/Data	☐									
Equip/Tooling	☐									
Handling/Pre	☐									
Material	☐									
Operator	☐									
Offset/Setup	☐									
Process	☐									
Supplier	☐									
Training	☐									
Transport	☐									
Unapproved	☐									

FAULT CATEGORY

Landing Gear

☐ Bending
☐ Centre Not Concentric
☐ Cracks
☐ Crimp/Kink/Ripple/Wave
☐ Cuffs
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☐ Heat Treat
☐ Inspection Strip in Tube
☐ Marks/Chatter
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General

☐ Bend
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☐ Burrs
☐ Contamination
☐ Countersink
☐ Cut Too Short
☐ Drawing
☐ Drill Holes
☐ Finish
☐ Fit/Function
☐ Folio/Program
☐ Grain
☐ Hardware
☐ Inspection Incomplete/Unqualified
☐ Instructions Incomplete/Unclear
☐ Misaligned/off center
☐ Mislabeled
☐ Misread
☐ Off-set
☐ Out of Calibration
☐ Out of Sequence
☐ Outside Dimensions
☐ Over/Under tolerance
☐ Part Incorrect
☐ Part Lost/Missing
☐ Part Moved
☐ Positioned Wrong
☐ Power Loss/Surge
☐ Pressure/Forced
☐ Set-up
☐ Temperature/Cure
☐ Weld
☐ Wrong Stock Pulled
☐ Other

Picklist Print

April-24-14 8:49:56 AM

Work Order ID: 116988

116988

Parent Item: D3256-3

D3256-3

Parent Item Name: Gasket

Start Date: 4/23/14 **Required Date:** 4/23/14

Start Qty: 6.00 **Required Qty:** 6.00

Comments: IPP B04.12.06Made in-houseKJ/JLM
IPP Rev:C ecn 1052/water jet 07-11-05 DD verified by:EC IPP REV:D
12.11.07 AS PER DWG REV.C DD VERF:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
G89		Purchased	No			100	sf	14.5000	1.02				
G89 Coated Cloth									**	10		JM14-05-30	

Location	Loc Qty	Loc Code
MAT052	14.5	
123993	4.5	
124498	10	

~~123993~~ 124498 5 sq. ft.

94714 5 sq. ft.

D3245
Gasket
(G-89)

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

DART AEROSPACE

QA Closed: Date: Work Order update only ☐

Work Order: _____

Part No. _____

NCR No. _____

DISPOSITION

- Rework ☐
- Scrap ☐
- Use-as-is ☐
- Suspected Unapproved ☐

AGAINST DEPARTMENT/PROCESS

Skid-tube ☐	Crosstube ☐	Water Jet ☐	Engineering ☐
Machining ☐	Small Fab ☐	Prod. Eng. Coor. ☐	Quality ☐
Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐
Large Fab ☐	Composite ☐	Supplier ☐	☐

Root Cause		Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design	☐									
Doc/Data	☐									
Equip/Tooling	☐									
Handling/Pre	☐									
Material	☐									
Operator	☐									
Offset/Setup	☐									
Process	☐									
Supplier	☐									
Training	☐									
Transport	☐									
Unapproved	☐									

FAULT CATEGORY

Landing Gear

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- ☐ Crushing
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- ☐ Marks/Chatter
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General

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- ☐ BOM/Route
- ☐ Broken/Damage/Defect
- ☐ Burrs
- ☐ Contamination
- ☐ Countersink
- ☐ Cut Too Short
- ☐ Drawing
- ☐ Drill Holes
- ☐ Finish
- ☐ Fit/Function
- ☐ Folio/Program
- ☐ Grain
- ☐ Hardware
- ☐ Inspection Incomplete/Unqualified
- ☐ Instructions Incomplete/Unclear
- ☐ Misaligned/off center
- ☐ Mislabeled
- ☐ Misread
- ☐ Off-set
- ☐ Out of Calibration
- ☐ Out of Sequence
- ☐ Outside Dimensions
- ☐ Over/Under tolerance
- ☐ Part Incorrect
- ☐ Part Lost/Missing
- ☐ Part Moved
- ☐ Positioned Wrong
- ☐ Power Loss/Surge
- ☐ Pressure/Forced
- ☐ Set-up
- ☐ Temperature/Cure
- ☐ Weld
- ☐ Wrong Stock Pulled
- ☐ Other

DART AEROSPACE LTD	Work Order:	116988
Description: Access Panel	Part Number:	D3256-3
Inspection Dwg: D3256 **Rev:** E		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
24.00	+/-0.030	24.00"	–		T	JTM07
6.10	+/-0.030	6.10"	–		V	JTM07
11.25	+/-0.030	11.25"	–		V	
10.55	+/-0.030	10.55"	–		V	
1.60	+/-0.030	1.60"	–		V	
1.50	+/-0.030	1.50"	–		V	
4.15	+/-0.030	4.15"	–		V	
1.30	+/-0.030	1.30"	–		V	
0.65	+/-0.030	0.65"	–		V	
0.65	+/-0.030	0.65"	–		V	
1.50	+/-0.030	1.50"	–		V	

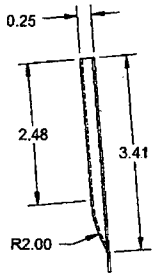
Measured by:	JM
Date:	14-05-30

DAS 27 (89)

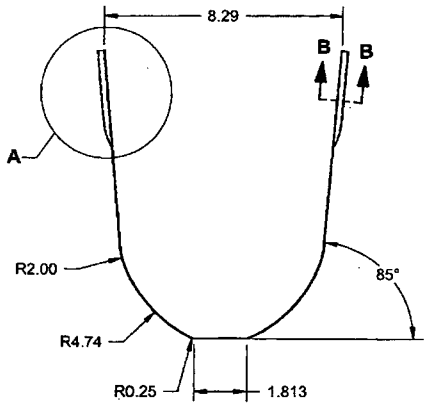
Audited by:	
Date:	14/5/30

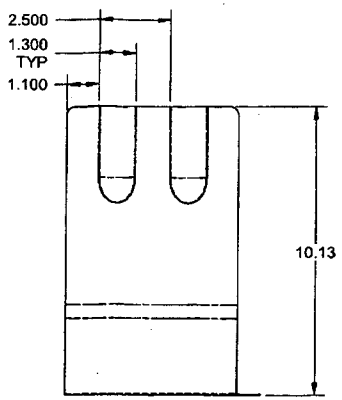
Preliminary Approval:	
Date:	

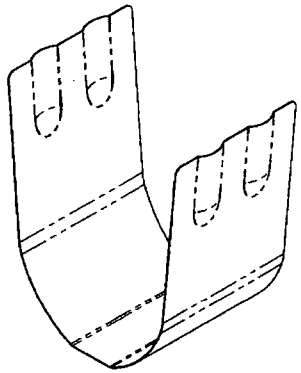
Rev	Date	Change	Revised by	Approved
A	07.11.23	New Issue	KJ/EC/DD	
B	12.06.19	Dimensions updated per Dwg Rev D	KJ	



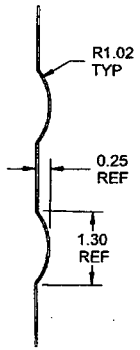
DETAIL A
SCALE 2X



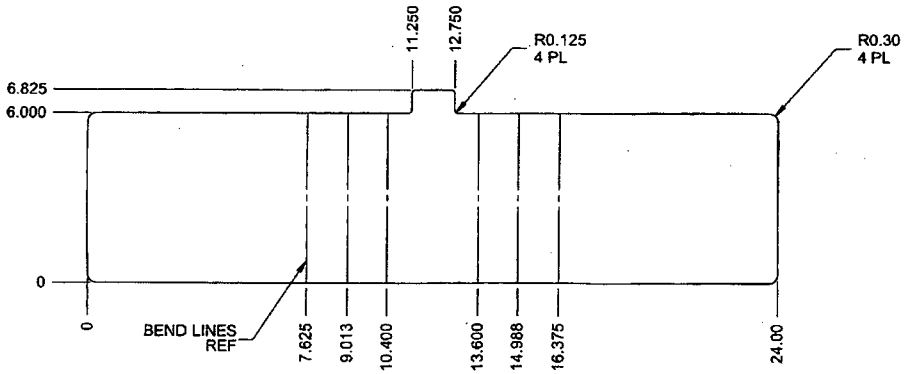




D3256-1 ACCESS PANEL
(MAKE FROM D3256-1F)



SECTION B-B
SCALE 2X
(VIEW ROTATED)



D3256-1F FLAT PATTERN 1

RELEASED
2012 -11- 06

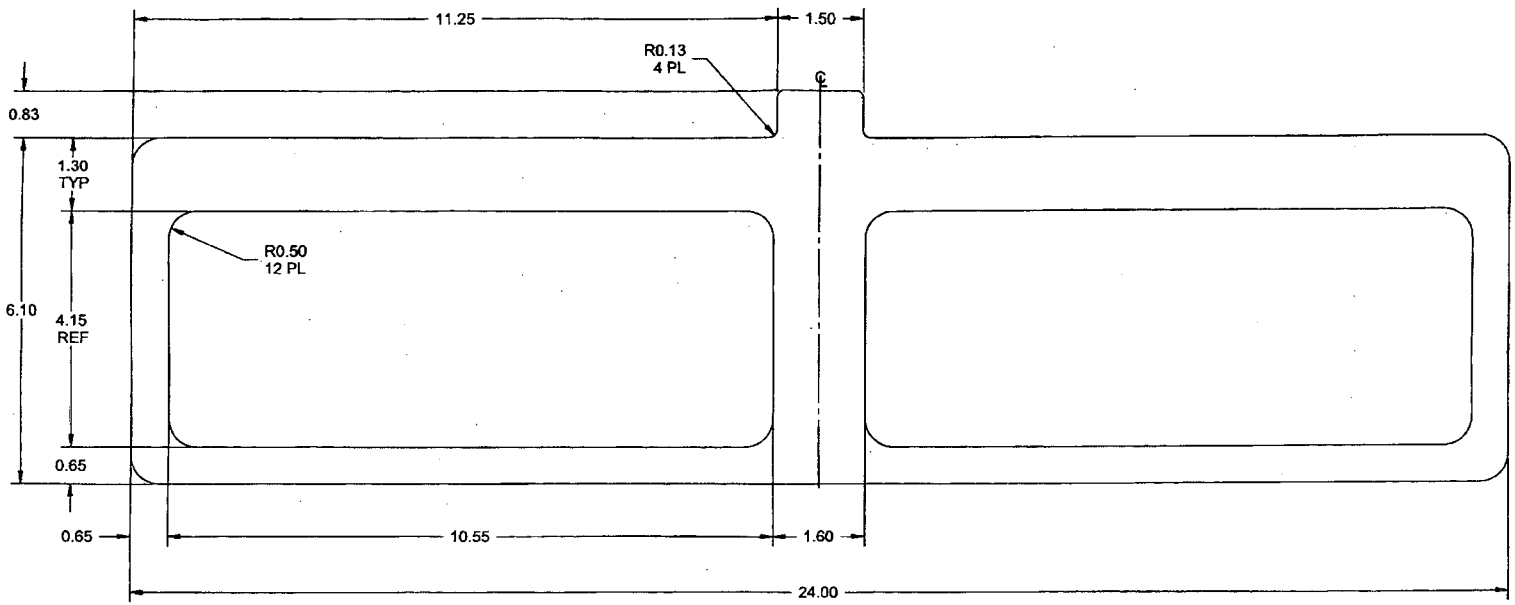
116988 MLS
14-04-28

NOTES:
1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET ANNEALED 2B FINISH, 0.032 THICK
PER MIL-S-5019 OR AMS 5513/AMS 5524 OR ASTM A240 OR ASME SA240
REF. DART SPEC. M304S22GA
2) FINISH: NONE
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3256-1" AND S/N "BXXXXX" PER DART QSI 044 6.1 (FINE POINT PAINT MARKER)
7) WEIGHT: 1.37 lbs

REV.	DESCRIPTION	BY	DATE
E	CHANGED MATERIAL FOR D3256-3. REASON: PROCUREMENT, REF CAR12-69.	MB	12.10.16
D	UPDATED TO COMPLY WITH QSI 043; REMOVED "FORM JOGGLE PER D3256-1T1" AND "FORM PER D3256-1T2" (SEE PREVIOUS REV FOR REFERENCE); 6.825 WAS 6.450 (ZN B7-1); 0.83 WAS 0.45 (ZN C8-2). REASON: PAR11-124.	MB	11.10.25
C	D3256-041 ELIMINATED: REMOVED (QTY 22) 0.128 HOLES FROM D3256-1F AND D3256-3 GASKET. INSTRUCTIONS TO DRILL HOLES AND INSTALL D3256-3 GASKET ARE NOW PART OF THE INSTALLATION INSTRUCTIONS	MB	07.09.28
B	D3256-3 DIM 1.30 WAS 0.65	RF	05.06.27
A	NEW ISSUE	RF	04.01.27

DESIGN		**DART AEROSPACE LTD**
DRAWN		HAWKESBURY, ONTARIO, CANADA
CHECKED		DRAWING NO. REV. E
MFG. APPR.		D3256 SHEET 1 OF 2
APPROVED		TITLE SCALE
DE APPR.		ACCESS PANEL NTS
DATE	12.10.16	

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D3256-3 GASKET

RELEASED
2012 -11- 06

NOTES:
1) MATERIAL: THERMO-CHEM P/N G-89, 0.060 THICK
POSSIBLE SUPPLIER: A.R. THOMSON GROUP (E)
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: N/A
6) IDENTIFICATION: N/A
7) WEIGHT: 0.12 lbs

DESIGN		DART AEROSPACE LTD
DRAWN		HAWKESBURY, ONTARIO, CANADA
CHECKED		DRAWING NO. D3256 REV. E
MFG. APPR.		SHEET 2 OF 2
APPROVED		TITLE ACCESS PANEL SCALE NTS
DE APPR.		
DATE 12.10.16		

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